

Work Order ID 147261

Wednesday, June 08, 2016 2:24:14 PM

147261

Page 1

Item ID: D4982-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 6/6/2016 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 6/8/2016 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MCS Date: JUN 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4982	C								

110	Pick Kit	0.00							
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110

Packaging	Memo	0.00							
Packaging									

120

120

Small Fab	Memo	0.20							
Small Fab	Torque hardware as per dwg								

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 8.

A/R RTV LOCTITE 598: 135475
exp. date: 01/18

2x 16/06/2016 DAS 86 988

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130						2			DAS 38 9-89
QC	Memo	0.01							OCT 27 2016
Quality Control									
140	Identify as per dwg & Stock Locations <i>CCK035</i>	0.00				2			
140									DAS 6 9-89
Packaging	Memo	0.00							NOV 01 2016
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									DAS 21 9-89
QC	Memo	0.03							NOV 01 2016
Quality Control									

M/6-11-01

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
		OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 147261

147261

Parent Item: D4982-041

D4982-041

Parent Item Name: Upper Cutter Assembly

Start Date: 6/6/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.011.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5140-1 *D5140-1* Upper Cutter Body, LH		Manufactured	No				Each	5.0000	**	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK133				5					
				125788				5					
D5140-2 *D5140-2* Upper Cutter Body, RH		Manufactured	No				Each	5.0000	**	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK133				5					
				125828				5					
D4839-1 *D4839-1* Blade		Manufactured	No				Each	19.0000	**	4			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK128				19					
				141328				19					
D4973-1 *D4973-1* Upper Cutter Deflector		Manufactured	No				Each	0.0000	**	2			DAS 6 9-89
D4974-1 *D4974-1* Upper Rail		Manufactured	No				Each	0.0000	**	2			DAS 6 9-89

SEP 19 2016

SEP 19 2016

DQA: _____ Date: _____

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Parent Item: D4982-041

D4982-041

Parent Item Name: Upper Cutter Assembly

Start Date: 6/6/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149CN832R

Purchased

No

Each

308.0000

56

NAS1149CN832R

Washer

DAS
6
8-09

Location

Loc Qty

Loc Code

ST266

308

116038

18

124580

250

125268

40

Each

39.0000

28

DAS
6
8-09

MS27039C0819

Purchased

No

MS27039C0819

Screw

Location

Loc Qty

Loc Code

ST276

39

m130822

39

Each

108.0000

28

DAS
6
8-09

MS21043-08

Purchased

No

MS21043-08

Nut, Self Locking

Location

Loc Qty

Loc Code

ST304

108

M130505

70

M131317

38

28

SEP 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

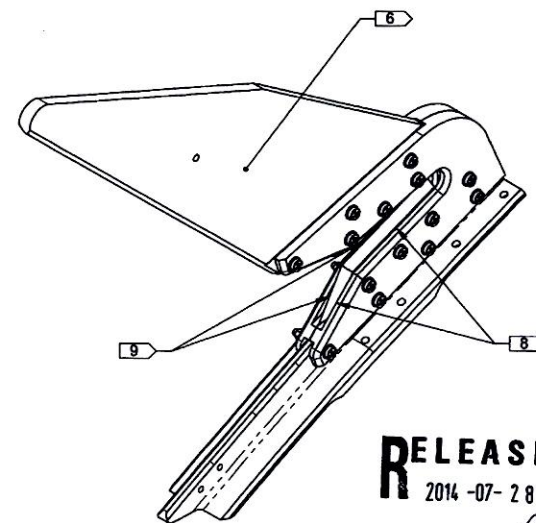
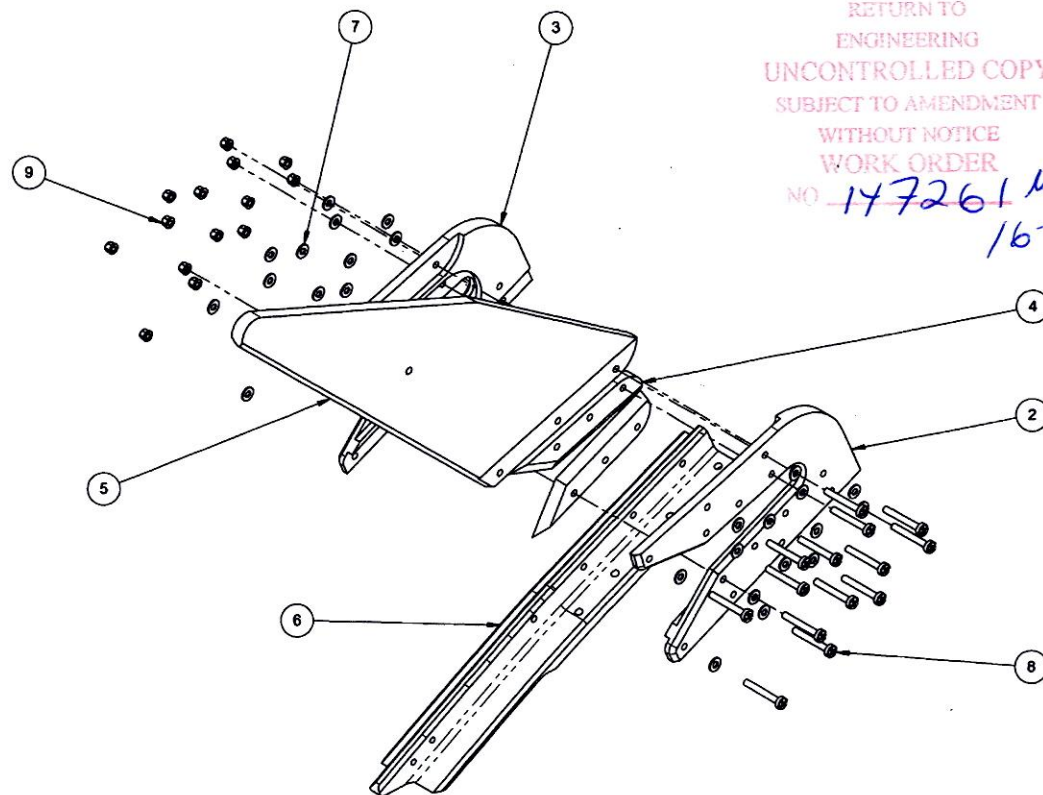
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OTHER : _____					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 147261 MJS
16-06-09

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4982-041	UPPER CUTTER ASSY
2	1	D5140-1	UPPER CUTTER BODY LH
3	1	D5140-2	UPPER CUTTER BODY RH
4	2	D4839-1	BLADE
5	1	D4973-1	UPPER CUTTER DEFLECTOR
6	1	D4974-1	UPPER RAIL
7	28	NAS1149CN832R	WASHER
8	14	MS27039C0819	SCREW
9	14	MS21043-08	NUT



RELEASED
2014-07-28

D4982-041 UPPER CUTTER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4982-041", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 4.46 lbs (2.03 kgs)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.
- 10) TORQUE HARDWARE TO 12-15 in-lbs (1.4-1.7 N-m)

C	REVISED BILL OF MATERIALS	AK	14.07.18
B	REVISED D4973-1 (ZN C3-1) AND D4974-1 (ZN B2-1)	AK	14.05.26
A	NEW ISSUE	DC	13.11.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	AK		
CHECKED	RF		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.07.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4982
TITLE
UPPER CUTTER ASSY
REV. C
SHEET 1 OF 1
SCALE
NTS

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